

Date: Thursday, 11/10/2007 11:12:49 AM
 User: Linda Lacelle

Process Sheet

| | | | | | | |
|-----------------------|---|--|------------------|----------------------------|--|--|
| Customer | CU-DAR001 Dart Helicopters Services | | Drawing Name | HIGH AFT X-TUBE 412 | | |
| Job Number | 35106 | | Part Number | D412664203 | | |
| Estimate Number | 10559 | | Drawing Number | D412-664-243 REV D | | |
| P.O. Number | N/A | | Project Number | N/A | | |
| This Issue | 11/10/2007 S.O. No. : N/A | | Drawing Revision | D | | |
| Prsht Rev. | NC | | Material | N/A | | |
| First Issue | N/A | | Due Date | 31/10/2007 Qty: 1 Um: Each | | |
| Previous Run | 35056 | | | | | |
| Written By | | | | | | |
| Checked & Approved By | | | | | | |
| Comment | Est Rev:E 04.02.16 Reformat; Added D3189-1 K/DS Est Rev:F 06-03-29 Remove Coments on Pick List JLM Est Rev:G 06.12.08 per ECN 886 EC Est Rev:H 07-04-30 As per Rev D JLM | | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---|-----------------------|----------------------------------|
| 1.0 | DC | DOCUMENT CONTROL |
| Comment: DOCUMENT CONTROL Photocopy bluefile and create labels as per PPP D412-664-203 CHG 006 | | |
| 2.0 | D6009129 | Crosstube Material |
| Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part number Description Batch 1 D6009-129 Crosstube B25668 Check OD = 3.500"; ID = 2.250" | | |
| 3.0 | MORI SEIKI | MORI SEIKI CNC LATHE LARGE |
| Comment: MORI SEIKI CNC LATHE LARGE 1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA166 2-Turn first side as per Folio FA166 3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243. | | |
| 4.0 | QC1 | INSPECT ALL DIM TO DIM SHEET |

Comment: INSPECT ALL DIM TO DIM SHEET

JL 07/10/15

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 11/10/2007 11:12:49 AM
User: Linda Lacelle

Process Sheet

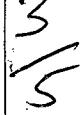
| Customer: CU-DAR001 Dart Helicopters Services | | Drawing Name: HIGH AFT X-TUBE 412 |
|--|-----------------------|---|
| Job Number: 35106 | | Part Number: D412664203 |
| Job Number: | | |
| Seq. #: | Machine Or Operation: | Description : |
| 5.0 | MORI SEIKI | MORI SEIKI CNC LATHE LARGE |
| Comment: MORI SEIKI CNC LATHE LARGE | | |
| 1-Turn second side as per Folio FA166 | | |
| 2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243. | | |
| 3- Remove sand and plugs | | |
| 4-Scribe part # and batch # using vibrating stylus as per Dwg D412-664-243 (engrave on outside of tube) | | Inside of Cuff(Donot J.L 07/10/15) |
| 6.0 | QC1 | INSPECT ALL DIM TO DIM SHEET |
| Comment: INSPECT ALL DIM TO DIM SHEET J.L 07/10/15 | | |
| 7.0 | QC8 | SECOND CHECK |
| Comment: SECOND CHECK <i>ultrasonic eng approve</i> | | JL 07/10/15 |
| 8.0 | LANDING GEAR 1 | LANDING GEAR RESOURCE 1 |
| Comment: LANDING GEAR RESOURCE 1 JB 7-10-22 | | |
| 9.0 | QC5 | INSPECT WORK TO CURRENT STEP |
| Comment: INSPECT WORK TO CURRENT STEP E 07/10/22 | | |
| 10.0 | HAND FINISHING 1 | HAND FINISHING RESOURCE #1 |
| Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 JB 7-10 - 23 | | |
| 11.0 | QC3 | INSPECT POWDER COAT/CHEMICAL CONVERSION |
| Comment: Inspect work & Chemical conversion Coat 08 07/10/23 | | |

W/O:

WORK ORDER CHANGES

| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
|------|------|------------------|----|------|-----|-------------------------------------|--------------------------|
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/10/09
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------|--|---|---------------------------------|---|----------------|---|-----------------------|---------------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 07/10/17 | 3  5 | Tubes were turned slightly off center. - material also not perfectly straight. R.C.: Tail stock was off center/Human error on set-up. | CP 07/10/17 PV QSI 042 | Ultrasonic measure the wall thickness, along inclined Around the tube existing dimensions. | CP 07/10/15 |  | 07/10/17 | IP 07/10/17 PV QSI 042 |
| | | | | * tube acceptable see attached | QSI 042 | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 11/10/2007 11:12:49 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 35106

Part Number: D412664203

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 BENDING BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D412-664-243 using CNC bender program 412-af and Folio FT010

EL 7-10-23

13.0 QC15 DIMENSIONAL CHECK OF X-TUBES



QC10-24①



Comment: DIMENSIONAL CHECK OF X-TUBES

14.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551

SR/SL

7-10-24

2-Ream hole to finish size in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243

15.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



ANM 07-10-25



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

16.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

EP 07/10/26

17.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/10/26

18.0 OUTSIDE SERV.10 OUTSIDE SERVICES -LG



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038Or

Issue P/O: 4916 LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

C 07/10/26 ①

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 11/10/2007 11:12:50 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 35106

Part Number: D412664203

Job Number:



Seq. #: Machine Or Operation:

Description :

19.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

CY 07/10/30 (1)

20.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: Inspect for damage & ensure results are as per Dwg D412-664-203

BT 07/10/30

21.0 SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

} BT 07-10-30

2-Paint outside crosstube with White Imron as per QSI 005 4.2

22.0 QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

BT 07/10/31

23.0 D3595

Rubber Cushion (per sq ft)



Comment: Qty.: 0.0492 sf(s)/Unit Total : 0.0492 sf(s)

Rubber Cushion (per sq ft)

.630" x5.70" x2pcs

Batch: 33835

BT 07-10-30

24.0 D2856600

Abrasion Strip



Comment: Qty.: 1.7640 f(s)/Unit Total : 1.7640 f(s)

Pick:

Qty Part number Description Batch

2 D2856-600(Cut to 10.090") Abrasion Strip

25656

BT 07-10-31

25.0 D28961

Support



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D2896-1

Support

30200

BT 07-10-31

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Thursday, 11/10/2007 11:12:50 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 35106

Part Number: D412664203

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---|
| 26.0 | D31891 | Chafing Shield |
| | | Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part number Description Batch 2 D3189-1 Chafing Sheild <u>30201x1</u> <u>2</u> <u>BT</u> <u>07-10-31</u> |
| 27.0 | MS2192028 | Clamp(per MIL-DTL-8783C) |
| | | Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Qty Part number Description Batch 4 MS21920-28 Clamp <u>104423</u> <u>BT</u> <u>07-10-31</u> |
| 28.0 | MS2192030 | clamp(per MIL-DTL-8783C) |
| | | Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) clamp(per MIL-DTL-8783C) batch: <u>100154</u> <u>BT</u> <u>07-10-31</u> |
| 29.0 | LANDING GEAR 1 | LANDING GEAR RESOURCE 1 |
| | | Comment: LANDING GEAR RESOURCE 1 Assemble as per Dwg D412-664-203 1-Install supports with magnobond as per QSI 015 Adhere for for 12 Hrs A/R 6398 Magnobond Batch: <u>104677</u> <u>BT</u> <u>07-10-31</u> Expiry Date: <u>08-10-01</u> |
| | | 2-Install clamps as per Dwg D212-664-141. Torque clamps to 80-100 in lb. |
| 30.0 | QC5 | INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP <i>S. orluloy</i> |
| 31.0 | PACKAGING 1 | PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Pick Packing Kit |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Date: Thursday, 11/10/2007 11:12:50 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 35106

Part Number: D412664203

Job Number:



Seq. #: Machine Or Operation:

Description :

32.0

AN640A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M104517

33.0

AN641A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M104427

34.0

AN960JD616

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Washer

Batch: M105125

35.0

MS21042L6

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

Batch: M104374

36.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

37.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

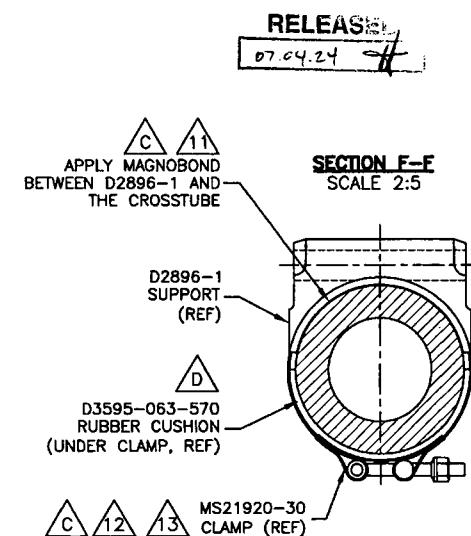
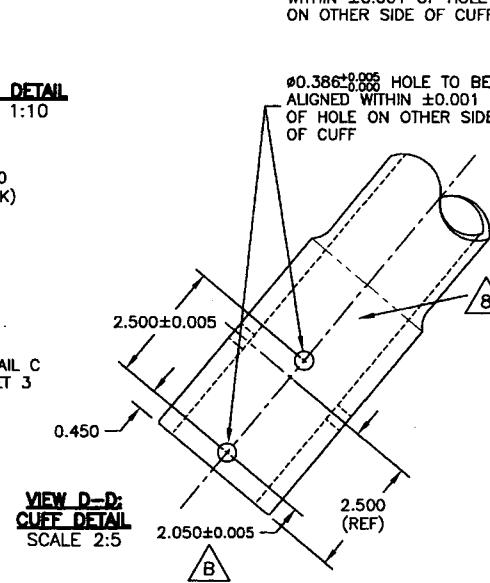
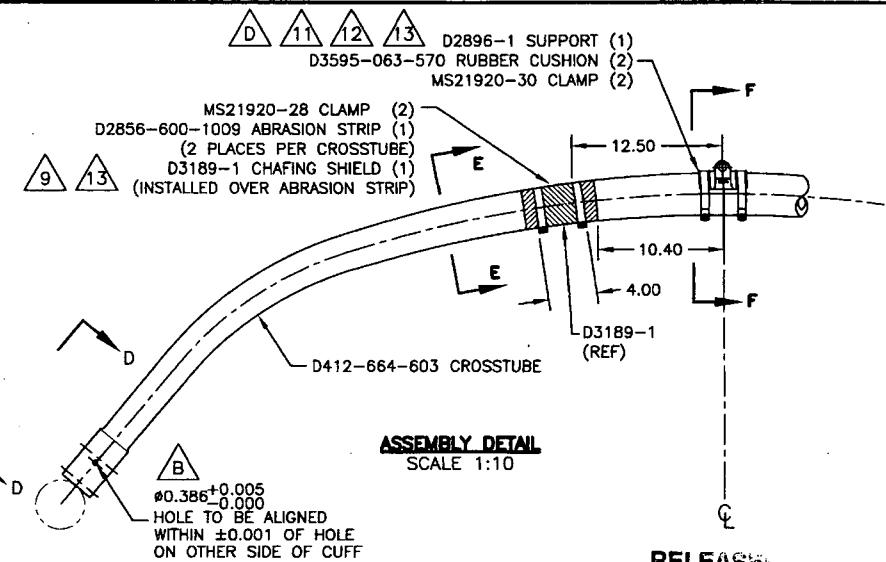
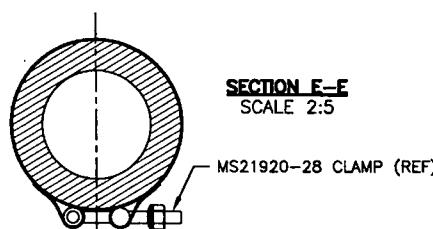
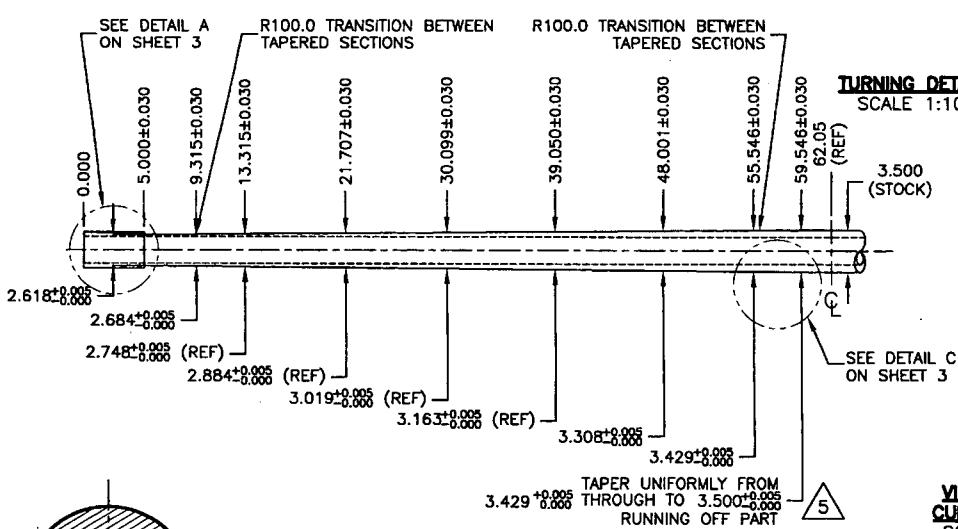
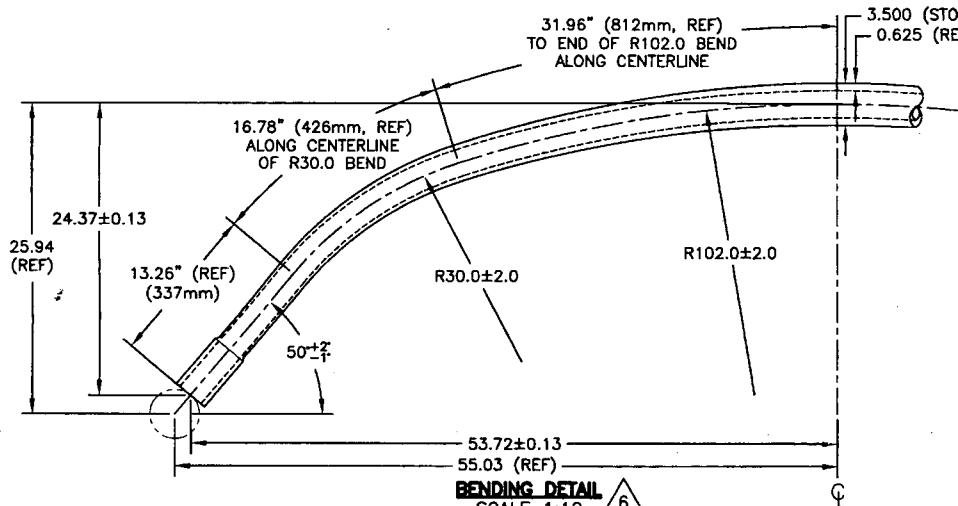
Identify and pack for shipping as per PPP D412-664-203

*****Ensure tube is not packaged if curing time is less than 12 hrs, see step 27 for application time & date

Time & date of packaging: 7-11-09 @ 10:AM

Location: G
PPP Rev: G

Sel YX

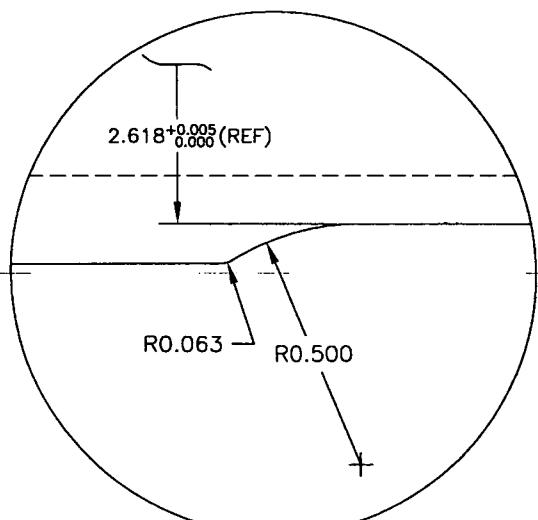
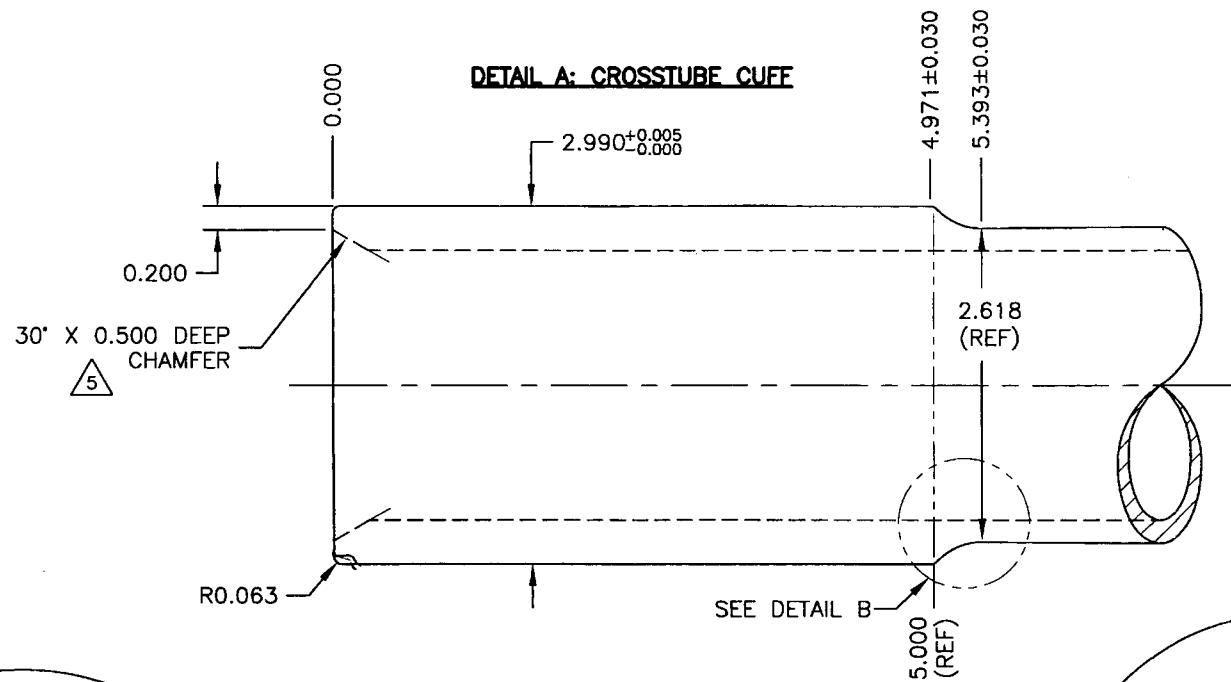


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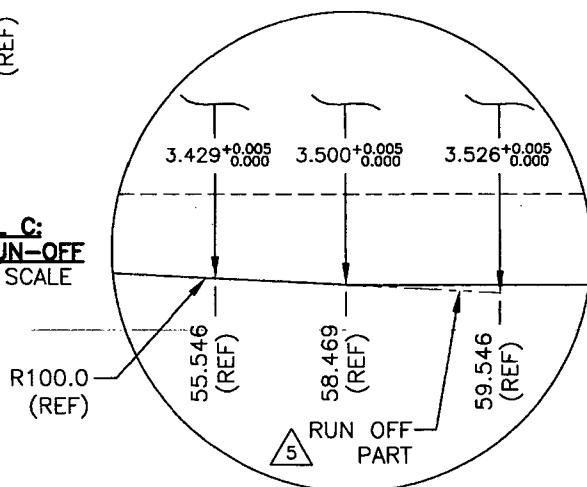
| DESIGN | DRAWN BY | DART | DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA |
|-------------------------------|--------------------------------|--|--|
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | | REV. D |
| | | DRAWING NO. D412-664-243 | SHEET 2 OF 3 |
| DATE 07.03.09 | | TITLE CROSSTUBE ASSEMBLY (412 HI AFT) | SCALE 1:10 |

RELEASED
07-04-241P
PER ECN 887



DETAIL B: CUFF TRANSITION
SCALE 4:1

**DETAIL C:
TAPER RUN-OFF**
NOT TO SCALE



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DESIGN

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DRAWN BY

PH

DART

DART AEROSPACE LTD.
HAWKESBURY, ONTARIO, CANADA

REV. D

SHEET 3 OF 3

SCALE

1:1

CHECKED

APPROVED

DRAWING NO.

D412-664-243

DATE

TITLE

CROSSTUBE ASSEMBLY (412 HI AFT)

07.03.09

| | | |
|--|--------------|--------------|
| DART AEROSPACE LTD | Work Order: | 35106 |
| Description: Crosstube Assembly (412 High Aft) | Part Number: | D412-664-243 |
| Inspection Dwg: D412-664-243 Rev: B | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

| Inspection Sheet Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|------------------------------------|-----------|------------------|---------|--------|----------------------|----------|
| SIDE A | 2.684 | +0.005/-0.000 | 2.689 | | | |
| | 2.748 | +0.005/-0.000 | 2.753 | ✓ | | |
| | 2.884 | +0.005/-0.000 | 2.888 | ✓ | | |
| | 3.019 | +0.005/-0.000 | 3.024 | ✓ | | |
| | 3.163 | +0.005/-0.000 | 3.166 | ✓ | | |
| | 3.308 | +0.005/-0.000 | 3.310 | ✓ | | |
| | 3.429 | +0.005/-0.000 | 3.431 | ✓ | | |
| | 2.990 | +0.005/-0.000 | 2.995 | ✓ | | |
| | 2.618 | +0.005/-0.000 | 2.622 | ✓ | | |
| | 0.200 | +/-0.010 | .180 | | | |
| | R0.063 | +/-0.010 | -.063 | ✓ | | |
| | R0.500 | +/-0.010 | .500 | ✓ | | |
| | 4.971 | +/-0.001 | 4.975 | ✓ | | |
| | | | | | | |
| SIDE B | 2.684 | +0.005/-0.000 | 2.688 | ✓ | | |
| | 2.748 | +0.005/-0.000 | 2.752 | ✓ | | |
| | 2.884 | +0.005/-0.000 | 2.888 | ✓ | | |
| | 3.019 | +0.005/-0.000 | 3.023 | ✓ | | |
| | 3.163 | +0.005/-0.000 | 3.166 | ✓ | | |
| | 3.308 | +0.005/-0.000 | 3.313 | ✓ | | |
| | 3.429 | +0.005/-0.000 | 3.434 | ✓ | | |
| | 2.990 | +0.005/-0.000 | 2.994 | ✓ | | |
| | 2.618 | +0.005/-0.000 | 2.622 | ✓ | | |
| | 0.200 | +/-0.010 | .180 | | | |
| | R0.063 | +/-0.010 | -.063 | / | | |
| | R0.500 | +/-0.010 | .500 | / | | |
| | 4.971 | +/-0.001 | 4.975 | / | | |
| | 124.09 | +/-0.020 | 124.100 | ✓ | | |
| | | | | | | |

| | | | | | |
|--------------|----------|-------------|----------|---------------------|-----|
| Measured by: | J.L | Audited by: | S.V | Prototype Approval: | N/A |
| Date: | 07/10/15 | Date: | 07/10/18 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|------------------------------|------------|----------|
| A | 04.06.16 | New Issue (P/O D412-664-203) | KJ/JLM | |
| B | 06.03.09 | Dwg Rev updated | KJ/JLM | . |

DART AEROSPACE LTD

Work Order: 35106

Description: Crosstube Assembly HIGH AFT X-TUBE 9L2

Part Number: D412664203

Inspection Dwg: D412-664-243 Rev: D

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

 First Article Prototype

| Inspection Sheet Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|------------------------------------|-----------|------------------|--------|--------|----------------------|----------|
| SIDE A | 1 | 2 | 3 | 4 | | |
| | 0.369 | 0.381 | 0.395 | 0.389 | | |
| | 0.204 | 0.214 | 0.251 | 0.245 | | |
| | 0.234 | 0.246 | 0.285 | 0.279 | | |
| | 0.303 | 0.308 | 0.354 | 0.356 | | |
| | 0.373 | 0.369 | 0.422 | 0.431 | | |
| | 0.447 | 0.442 | 0.497 | 0.504 | | |
| | 0.529 | 0.515 | 0.562 | 0.577 | | |
| | 0.589 | 0.584 | 0.621 | 0.632 | | |
| | | | | | | |
| SIDE B | 0.362 | 0.370 | 0.403 | 0.399 | | |
| | 0.202 | 0.203 | 0.251 | 0.253 | | |
| | 0.229 | 0.237 | 0.292 | 0.284 | | |
| | 0.295 | 0.296 | 0.364 | 0.365 | | |
| | 0.372 | 0.361 | 0.428 | 0.435 | | |
| | 0.446 | 0.429 | 0.500 | 0.513 | | |
| | 0.535 | 0.513 | 0.562 | 0.576 | | |
| | 0.594 | 0.581 | 0.622 | 0.634 | | |
| | | | | | | |
| | | | | | | |

→ 40.628 MEAN
±0.072 ELL.

| | |
|--------------|------------|
| Measured by: | <i>JMK</i> |
| Date: | 07/10/15 |

| | |
|-------------|-----------|
| Audited by: | <i>JP</i> |
| Date: | 07.10.17 |

| | |
|---------------------|-----|
| Prototype Approval: | N/A |
| Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/JLM | |

| THICKNESS MEASUREMENTS | | | | WALL PER DWG | MEAN | ECCENTRIC | | |
|------------------------|-------|-------|-------|--------------|--------------|-----------|-------|--------|
| | | | | | AVERAGE WALL | DIF | MIN | MAX |
| 0.369 | 0.381 | 0.395 | 0.389 | 0.37 | 0.384 | 0.014 | 0.025 | -0.001 |
| 0.204 | 0.214 | 0.251 | 0.245 | 0.217 | 0.229 | 0.012 | 0.034 | -0.013 |
| 0.234 | 0.246 | 0.285 | 0.279 | 0.249 | 0.261 | 0.012 | 0.036 | -0.015 |
| 0.303 | 0.308 | 0.354 | 0.356 | 0.317 | 0.330 | 0.013 | 0.039 | -0.014 |
| 0.373 | 0.369 | 0.422 | 0.431 | 0.385 | 0.399 | 0.014 | 0.046 | -0.016 |
| 0.447 | 0.442 | 0.497 | 0.504 | 0.457 | 0.473 | 0.016 | 0.047 | -0.015 |
| 0.529 | 0.515 | 0.562 | 0.577 | 0.529 | 0.546 | 0.017 | 0.048 | -0.014 |
| 0.589 | 0.584 | 0.621 | 0.632 | 0.590 | 0.607 | 0.017 | 0.042 | -0.006 |
| 0.362 | 0.37 | 0.403 | 0.399 | 0.37 | 0.384 | 0.014 | 0.033 | -0.008 |
| 0.202 | 0.203 | 0.251 | 0.253 | 0.217 | 0.227 | 0.010 | 0.036 | -0.015 |
| 0.229 | 0.237 | 0.292 | 0.284 | 0.249 | 0.261 | 0.012 | 0.043 | -0.020 |
| 0.295 | 0.296 | 0.364 | 0.365 | 0.317 | 0.330 | 0.013 | 0.048 | -0.022 |
| 0.372 | 0.361 | 0.428 | 0.435 | 0.385 | 0.399 | 0.014 | 0.050 | -0.024 |
| 0.446 | 0.429 | 0.5 | 0.513 | 0.457 | 0.472 | 0.015 | 0.056 | -0.028 |
| 0.535 | 0.513 | 0.562 | 0.576 | 0.529 | 0.547 | 0.018 | 0.047 | -0.016 |
| 0.594 | 0.581 | 0.662 | 0.634 | 0.590 | 0.618 | 0.028 | 0.072 | -0.009 |
| | | | | | | | 0.072 | -0.028 |

Dwg D6009 allows ± 0.063 WALL IN ECCENTRICITY
 ± 0.020 WALL MEAN

One dim is high ($+0.072 / +0.028$), however, it is one location
 only (won't have large effect on stiffness) and tube is obviously
 strong enough. Grinding/polishing will reduce this number.

P
07.10.17

DART AEROSPACE LTD

Work Order:

35106

Description: Crosstube High Aft (412)

Part Number:

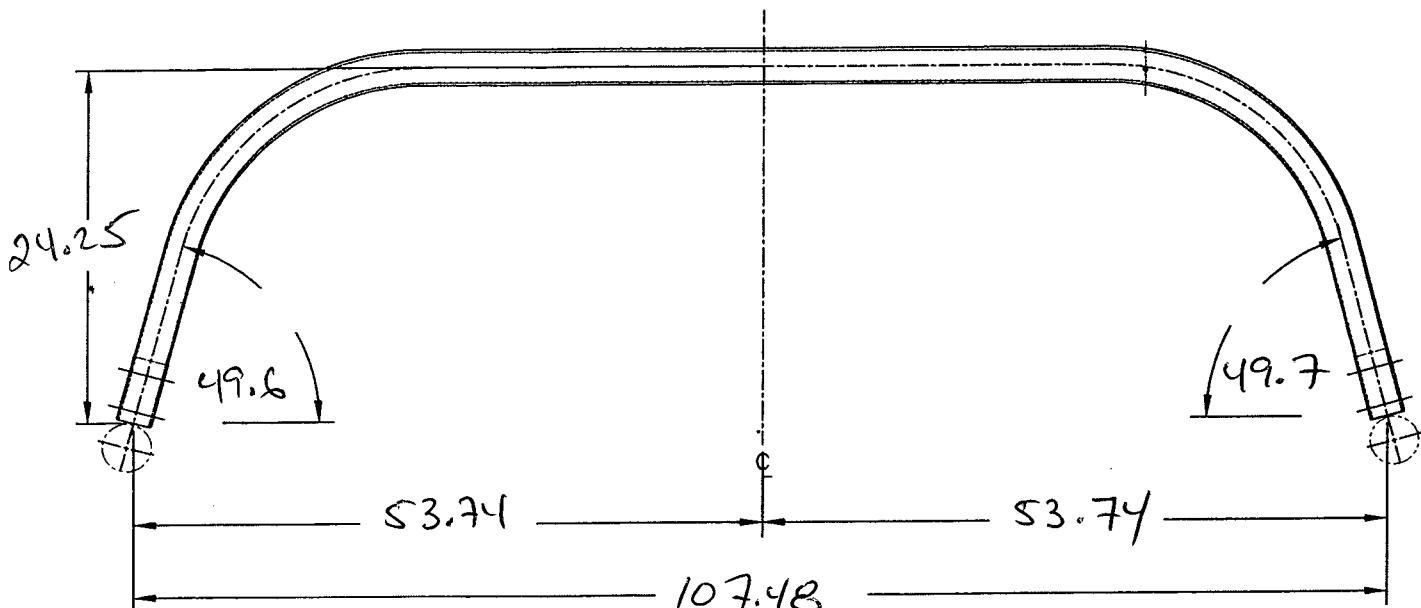
D412-664-203

Inspection Dwg: D412-664-243

Rev: D

Page 1 of 1

| Required Dimension | Min | Max |
|--------------------|--------|--------|
| Height | 24.24 | 24.50 |
| 1/2 Span | 53.59 | 53.85 |
| Angle | 49 | 52 |
| Total Span | 107.18 | 107.70 |



| Comments | |
|----------|--|
| | |
| | |
| | |
| | |
| | |

| | |
|-----------------|--------------------|
| QC15 Inspection | <i>[Signature]</i> |
| Date | 09.10.24 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------------------------------|------------|--------------------|
| A | 07.02.06 | New Issue | KJ/JM | <i>[Signature]</i> |
| B | 07.05.08 | Dimensions updated per Dwg rev. D | KJ/JLM | <i>[Signature]</i> |



LIQUID PENETRANT TEST REPORT

P- 09852

CLIENT
ATTENTION
ADDRESS

Dirt Aerospace
Linda Lacelle
1270 Aberdeen St
Hawkesbury, ON.

DATE

ACUREN JOB NO.

PO/WO NO.

WORK LOCATION

ACCEPTANCE STD. ASTM E117/OSI-CRS REV./DATE 2025

PROJECT

ITEM(S) EXAMINED

Fluorescent Liquid Penet. on 212/205 HIGH FEDX-TUBE + HIGH AFT X-TUBE 412
JOB#33540 Part# D412664203 + JOB#33539 + JOB#35555 + JOB#35556
+ JOB#35106 Also - JOB# 34928 Part# - D212664101

| JOB DESCRIPTION | PROCEDURE NO. LT0002 REV./DATE | TECHNIQUE NO. LT-TECH2 REV./DATE |
|-----------------|--------------------------------|----------------------------------|
|-----------------|--------------------------------|----------------------------------|

PART NO. D412664203 / D212664101 MATERIAL Anodized Alum THICKNESS

SCOPE Wet + Fluorescent Liquid Penetrant Inspection, 100% external surface

TEST DETAILS

| | | | | | |
|-------------------|---|----------------------------------|--|---|--|
| METHOD | <input checked="" type="checkbox"/> FLUORESCENT | <input type="checkbox"/> VISIBLE | <input checked="" type="checkbox"/> WATER WASH | <input type="checkbox"/> SOLVENT REMOVABLE | <input type="checkbox"/> POST EMULSIFIED |
| FAMILY BRAND | <u>Magniflux</u> | | BLACK LIGHT S/N <u>8165</u> | <input type="checkbox"/> OUTPUT > 1000 μW/cm ² | <input type="checkbox"/> AMBIENT < 2 fc |
| PENETRANT | <u>ZL-67</u> | MINIMUM DWELL TIME | <u>>45 MIN.</u> | LIGHTING EQUIP. <input type="checkbox"/> FLASHLIGHT <input type="checkbox"/> TROUBLELIGHT | <input type="checkbox"/> OUTPUT > 100 fc @ SURFACE |
| PENETRANT REMOVER | <u>H2O</u> | MINIMUM DRY TIME | <u>>10 MIN.</u> | OTHER <u>CAL DUE DATE - APR 17-08</u> | CAL DUE DATE |
| DEVELOPER | <u>SKD 32</u> | MINIMUM DWELL TIME | <u>10 MIN.</u> | LIGHT METER S/N | |
| DEVELOPER TYPE | <input checked="" type="checkbox"/> NON AQUEOUS | <input type="checkbox"/> AQUEOUS | <input type="checkbox"/> DRY | | |

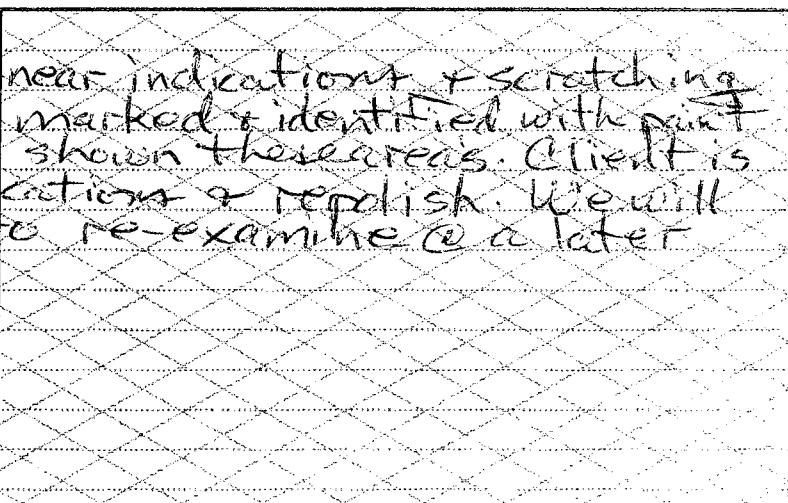
TEST SURFACE

| | | | | | |
|---------------------|---------------------------------------|---|-----------------------------------|--|--|
| SURFACE CONDITION | <input type="checkbox"/> AS GROUND | <input type="checkbox"/> AS WELDED | <input type="checkbox"/> MACHINED | <input type="checkbox"/> SHOT BLASTED | <input checked="" type="checkbox"/> CLEAN BARE METAL |
| SURFACE TEMPERATURE | <input type="checkbox"/> < -4°C/ 20°F | <input type="checkbox"/> - 4°C/ 20°F TO 10°C/50°F | | <input type="checkbox"/> 20°C/50°F TO 52°C/125°F | <input type="checkbox"/> > 52°C/125°F |

RESULTS- (METRIC IMPERIAL)

| ITEM | COMMENTS | ACCEPT | REJECT |
|---|----------|--------|--------|
| All Parts inspected had several linear indications + scratching on surface. These areas were marked + identified with paint stick. Client was not told + going to remove any rail indications + repolish. We will let them be called back to re-examine @ a later specified date. | | | |

See NLP 244



cope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

| | | |
|--|---|--|
| CLIENT REPRESENTATIVE: <u>Jason Murdoch</u> <small>PRINT</small> | <u>Jan Smith</u> <small>SIGNATURE</small> | DTR # <u>27455</u> |
| TECHNICIAN (SIGNATURE): <u>John</u> | | REPORT REVIEWED BY: |
| JAME (PRINT): <u>Pat Pivak</u> <small>1ST TECHNICIAN</small> | <small>2ND TECHNICIAN</small> | NAME <input type="text"/> INITIALS <input type="text"/> |
| CGSB LEVEL <u>II</u> CGSB REG. NO. <u>3387</u> | CGSB LEVEL <u>II</u> CGSB REG. NO. <u></u> | SNT LEVEL <u>II</u> SNT LEVEL <u></u> |

WHITE - CLIENT COPY

CANARY - OFFICE COPY

PINK - TECHNICIAN COPY

GOLD - OFFICE COPY

Dart Aerospace Ltd.

Date: Thursday, 10/01/2008 9:07:57 AM
 User: Linda Lacelle

Process Sheet

| | | | | | |
|----------------------------------|--------------------------------|-----------------|-------------------------|--------------|-----------------|
| Customer | : CC-DAR01 Dart Aerospace Ltd. | | Drawing Name | : D212-664 | |
| Job Number | : 36700 | | Part Number | : Z_CUSTOM | |
| Estimate Number | : 10804 | | Drawing Number | : ECN 1103 | |
| P.O. Number | : | | Project Number | : | |
| This Issue | : 10/01/2008 | S.O. No. | Drawing Revision | : | |
| Prshrt Rev. | : NC | | Material | : | |
| First Issue | : // | Type | LANDING GEAR | | |
| Previous Run | : 00015 | | Due Date | : 17/01/2008 | |
| Written By | : | | Qty: | 1 | Um: Each |
| Checked & Approved By | : | | | | |
| Comment | : | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|-----------------------|
| 1.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |

Comment: PACKAGING RESOURCE #1

35892 - 35891 - 35539

PULL FROM STK:

35929-35928-35890-35893-35927-35541 -
 32681-32684-32680-34586-32181
 ✓ D412-664-203 357205-35056-35106

ADD NEW PAPERWORK TO KITS IN STK

FAA STC: SR01298NY, PER ECN 1103

RETURN TO STOCK

17X 8/1/11 SP

| | | |
|-----|------|------------------------------|
| 2.0 | QC21 | FINAL INSPECTION/W/O RELEASE |
|-----|------|------------------------------|

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



11 08-06-11